



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4271-027
Job Sheet 180386



Part No: D4271-027

Job Qty: 1 ea

Part Name: End Fitting Assembly Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No: GLOSS BLACK

Due Date: 7/10/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP revA 11.07.20 new issue EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/10/18	7/10/18	0.00	0.00	Start Up Small Fab-3	8:30 AM	JUL 12 2018
100	Small Fab	1 pcs	7/10/18	7/10/18	0.00	0.61	Small Fab-6		DAS
110	QC	1 pcs	7/10/18	7/10/18	0.00	0.00	QC5		JAS
120	Packaging	1 pcs	7/10/18	7/10/18	0.00	0.00	Packaging3-2	5:37 PM	JUL 16 2018
130	QC21-SA	1 Ea	7/10/18	7/10/18	0.00	0.00	QC21	DAS 53 9-89	JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C13A	Bolt	2 Ea (2 ea)	90-Start up Operation	5067844
D4148-3	Stud Receiver, Lower	1 Ea (1 ea)	90-Start up Operation	5088596
D4148-5	Eyebolt Stud	1 Ea (1 ea)	90-Start up Operation	5088428
D4281-3	Spacer	1 Ea (1 ea)	90-Start up Operation	5090742
D4419-3	Aft Support Plate	2 Ea (2 ea)	90-Start up Operation	5058633 x1 5073 844
MS20427M4-20	Rivet	1 pcs (1 ea)	90-Start up Operation	5118429
MS20615-4M18	Rivet	10 Ea (10 ea)	90-Start up Operation	5083540
MS21043-4	Nut	2 Ea (2 ea)	90-Start up Operation	5060246
NAS1149C0432R	Washer	4 Ea (4 ea)	90-Start up Operation	5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C13A	2	63	0
	D4148-3	1	12	0
	D4148-5	1	8	0
	D4281-3	1	30	0
	D4419-3	2	9	0
	MS20427M4-20	1	28	0
	MS20615-4M18	10	62	0
	MS21043-4	2	812	0
	NAS1149C0432R	4	1,617	0

4357

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No: _____ NC _____ Date: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:16.6%;">Skid-tube ☐</td> <td style="width:16.6%;">Cross tube ☐</td> <td style="width:16.6%;">Water Jet ☐</td> <td style="width:16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																													
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																																		
Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																																			
		QTY Effective : _____		MRB (QSI042) Approval																																																																																																																																	
Deviation		Disposition				Completed By																																																																																																																															
Dart Aerospace Ltd. 1270 Aberdeen Street Haverhill, MA 01830 TEL: 1 800 532-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S091200 Part: D4271-027 Job No: 180386 Serial No/Batch: S091200 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/12/18						Lead hand / Supervisor Approval Verification																																																																																																																															
						QC / QA Coordinator Approval																																																																																																																															
<table style="width:100%; border: none;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table>		Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	<table style="width:100%; border: none;"> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Supplier</td><td>☐</td></tr> <tr><td>Training</td><td>☐</td></tr> <tr><td>Use for Testing</td><td>☐</td></tr> <tr><td>Poor Information</td><td>☐</td></tr> <tr><td>Rushing</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Past Due</td><td>☐</td></tr> </table>		Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	<table style="width:100%; border: none;"> <tr><td>Pressure/Forced</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td></tr> <tr><td>Temperature/Cure</td><td>☐</td></tr> <tr><td>Set-up</td><td>☐</td></tr> <tr><td>BOM/Route</td><td>☐</td></tr> <tr><td>Broken/Damage/Defect</td><td>☐</td></tr> <tr><td>Inspection Incomplete/Unqualified</td><td>☐</td></tr> <tr><td>Contamination</td><td>☐</td></tr> <tr><td>Countersink</td><td>☐</td></tr> <tr><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Instructions Incomplete/Unclear</td><td>☐</td></tr> <tr><td>Drill Holes</td><td>☐</td></tr> <tr><td>Power Loss/Surge</td><td>☐</td></tr> <tr><td>Folio/Program</td><td>☐</td></tr> <tr><td>Grain</td><td>☐</td></tr> <tr><td>Weld</td><td>☐</td></tr> <tr><td>Wrong Stock Pulled</td><td>☐</td></tr> <tr><td>Out of Sequence</td><td>☐</td></tr> <tr><td>Off-set</td><td>☐</td></tr> <tr><td>Mislabeled</td><td>☐</td></tr> <tr><td>Fit/Function</td><td>☐</td></tr> <tr><td>Misaligned/off center</td><td>☐</td></tr> <tr><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Part Moved</td><td>☐</td></tr> <tr><td>Drawing</td><td>☐</td></tr> <tr><td>Finish</td><td>☐</td></tr> <tr><td>Misread</td><td>☐</td></tr> <tr><td>Turning Sequence</td><td>☐</td></tr> </table>				Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
Environment	☐																																																																																																																																				
Design	☐																																																																																																																																				
Doc/Data	☐																																																																																																																																				
Equip/Tooling	☐																																																																																																																																				
Handling/Pre	☐																																																																																																																																				
Material	☐																																																																																																																																				
Internal Transport	☐																																																																																																																																				
Tribal Knowledge	☐																																																																																																																																				
LOA	☐																																																																																																																																				
Substation	☐																																																																																																																																				
Past Expiry Date	☐																																																																																																																																				
Misidentified	☐																																																																																																																																				
Operator	☐																																																																																																																																				
Offset/Setup	☐																																																																																																																																				
Supplier	☐																																																																																																																																				
Training	☐																																																																																																																																				
Use for Testing	☐																																																																																																																																				
Poor Information	☐																																																																																																																																				
Rushing	☐																																																																																																																																				
Product Improvement	☐																																																																																																																																				
Process Improvement	☐																																																																																																																																				
Manufacturing Process	☐																																																																																																																																				
Past Due	☐																																																																																																																																				
Pressure/Forced	☐																																																																																																																																				
Bending	☐																																																																																																																																				
Centre Not Concentric	☐																																																																																																																																				
Cracks	☐																																																																																																																																				
Crimp/Kink/Ripple/Wave	☐																																																																																																																																				
Cuffs	☐																																																																																																																																				
Crushing	☐																																																																																																																																				
Heat Treat	☐																																																																																																																																				
Wave/Twist in Tube	☐																																																																																																																																				
Marks/Chatter	☐																																																																																																																																				
Temperature/Cure	☐																																																																																																																																				
Set-up	☐																																																																																																																																				
BOM/Route	☐																																																																																																																																				
Broken/Damage/Defect	☐																																																																																																																																				
Inspection Incomplete/Unqualified	☐																																																																																																																																				
Contamination	☐																																																																																																																																				
Countersink	☐																																																																																																																																				
Cut Too Short	☐																																																																																																																																				
Instructions Incomplete/Unclear	☐																																																																																																																																				
Drill Holes	☐																																																																																																																																				
Power Loss/Surge	☐																																																																																																																																				
Folio/Program	☐																																																																																																																																				
Grain	☐																																																																																																																																				
Weld	☐																																																																																																																																				
Wrong Stock Pulled	☐																																																																																																																																				
Out of Sequence	☐																																																																																																																																				
Off-set	☐																																																																																																																																				
Mislabeled	☐																																																																																																																																				
Fit/Function	☐																																																																																																																																				
Misaligned/off center	☐																																																																																																																																				
Positioned Wrong	☐																																																																																																																																				
Outside Dimensions	☐																																																																																																																																				
Over/Under tolerance	☐																																																																																																																																				
Part Incorrect	☐																																																																																																																																				
Part Lost/Missing	☐																																																																																																																																				
Part Moved	☐																																																																																																																																				
Drawing	☐																																																																																																																																				
Finish	☐																																																																																																																																				
Misread	☐																																																																																																																																				
Turning Sequence	☐																																																																																																																																				
		OTHER : _____																																																																																																																																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004351	S091182	AN4C13A	Bolt	s067894	ST344	2
004351	S091181	D4148-3	Stud Receiver, Lower	s088596	ST080	1
004351	S091180	D4148-5	Eyebolt Stud	s088428	ST080	1
004351	S091179	D4281-3	Spacer	s090742	ST084	1
004351	S058635	D4419-3	Aft Support Plate	S058634	ST090	1
004351	S091178	D4419-3	Aft Support Plate	s073844	ST090	1
004351	S091177	MS20427M4-20	Rivet	f118429	GA007	1
004351	S091176	MS20615-4M18	Rivet	s083540	ST306	10
004351	S091175	MS21043-4	Nut	s062296	ST302	2
004351	S091174	NAS1149C0432R	Washer	s050052	ST266	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/12/18 10:46 AM dart.quirion.sonia